

Date: Friday, 27/03/2009 8:53:30 AM  
 User: Chantal Lavoie

## Process Sheet

|  |  |
|--|--|
| <b>Customer</b> : CU-DAR001 Dart Helicopters Services  | <b>Drawing Name</b> : AFT X-TUBE EXT HEIGHT(-013)          |
| <b>Job Number</b> : 46712  |  |
| <b>Estimate Number</b> : 10563   |  |
| <b>P.O. Number</b> :   | <b>Part Number</b> : D205596107                            |
| <b>This Issue</b> : 27/03/2009 <b>S.O. No.</b> :   | <b>Drawing Number</b> : D205596107                         |
| <b>Prsht Rev.</b> : NC   | <b>Project Number</b> : N/A                                |
| <b>First Issue</b> : / / <b>Type</b> : CROSSTUBES  | <b>Drawing Revision</b> : B                                |
| <b>Previous Run</b> : 44383  | <b>Material</b> :  |
| <b>Written By</b> :  | <b>Due Date</b> : 10/04/2009 <b>Qty:</b> 1 <b>Um:</b> Each |
| <b>Checked &amp; Approved By</b> : <u>JLD 09.03.27</u>   |  |
| <b>Comment</b> : Est Rev:D 05.03.21 Added bending procedure KJ/JLM<br>Est Rev:E 08-01-10 ECN 1075 DD<br>Est Rev F 08.04.28 Added bending & mat'l EC<br>verified by: DD |  |

## Additional Product

Job Number:



|                |                              |                      |
|----------------|------------------------------|----------------------|
| <b>Seq. #:</b> | <b>Machine Or Operation:</b> | <b>Description :</b> |
|----------------|------------------------------|----------------------|

|     |    |                  |
|-----|----|------------------|
| 1.0 | DC | DOCUMENT CONTROL |
|-----|----|------------------|

**Comment:** DOCUMENT CONTROL

Photocopy D205-594 bluefile &amp; type labels per PPP D205-596-107 CHG002

|     |          |                     |
|-----|----------|---------------------|
| 2.0 | D6008180 | Crosstube Extrusion |
|-----|----------|---------------------|

**Comment:** Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Crosstube Extrusion

Batch: B39735

|     |               |                              |
|-----|---------------|------------------------------|
| 3.0 | BENDING CROSS | BENDING MACHINE - CROSSTUBES |
|-----|---------------|------------------------------|

**Comment:** BENDING MACHINE - CROSSTUBES

Bend as per Dwg D2889 using CNC bender program

|     |            |                       |
|-----|------------|-----------------------|
| 4.0 | CROSSTUBES | CROSSTUBES RESOURCE 1 |
|-----|------------|-----------------------|

**Comment:** LANDING GEAR RESOURCE 1

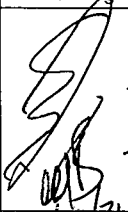

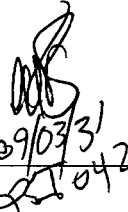

Mark 20.36" for cutting from tangential line in the straight section from D2890 as per Dwg wall template.

|     |      |                              |
|-----|------|------------------------------|
| 5.0 | QC15 | DIMENSIONAL CHECK OF X-TUBES |
|-----|------|------------------------------|

**Comment:** DIMENSIONAL CHECK OF X-TUBES

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: D205-596-107 PAR #: N/A Fault Category: Supplier / Muna NCR: (Yes) No DQA: D Date: 02/04/03  
 Resolution: SCRAP Disposition: SCRAP QA: N/C Closed: D Date: 02/04/03

| NCR: <u>46712</u> |      | WORK ORDER NON-CONFORMANCE (NCR)   |  |  |  |                           |  |  |
|-------------------|------|--|--|--|--|---------------------------|--|--|
| DATE              | STEP | Description of NC<br>Section A   | Corrective Action Section B  |  |  | Verification<br>Section C | Approval<br>Chief Eng  | Approval<br>QC Inspector   |
|                   |      |  | Initial<br>Chief Eng   | Action Description<br>Chief Eng  | Sign &<br>Date   |                           |  |  |
| 09/03/31          | 3.0  | 3x D600B-180 B39735<br>have broke in the bundle.<br>at the begining of the<br>process<br>P.C: see NCR 09-044 | <br>09/03/31<br>251042 | Scrap <del>check to be</del> tubes.<br>Qty 3.<br>See NCR 09-044<br>Recd tag: reference<br>NCR #. | <br>09/03/31 | S<br>09/03/31             | <br>09/03/31<br>251042 | <br>09/03/31 |
|                   |      |  |  |  |  |                           |  |  |
|                   |      |  |  |  |  |                           |  |  |

NOTE: Date & initial all entries

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Drawing Name: AFT X-TUBE EXT HEIGHT(-013)

Job Number: 46712

Part Number: D205596107

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

CROSSTUBES

CROSSTUBES RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Cut as per Dwg D205-596-107

2-Deburr & Inspect for surface damage. Polish cut surface. Scribe part # and batch # on one end of tube.

7.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

8.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Touch up ends of the tube with Chemical Conversion Coat per QSI 005 4.1

9.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

10.0

SPRAY PAINTING

SPRAY PAINTING



Comment: SPRAY PAINTING

1-Prime inside and outside with Immron per QSI 005 4.2

11.0

QC14

INSPECT SPRAY PAINT



Comment: Inspect Spray Paint

12.0

D3595063530

RUBBER CUSHION



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

RUBBER CUSHION

batch\_\_\_\_\_

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

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Job Number: 46712

Part Number: D205596107

Job Number:



Seq. #:

Machine Or Operation:

Description :

13.0

MS2192028

Clamp(per MIL-DTL-8783C)



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)  
clamp(per MIL-DTL-8783C)  
batch \_\_\_\_\_

14.0

D29401

Support



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)  
Pick:  
Qty Part number Description Batch  
2 D2940-1 Support \_\_\_\_\_

15.0

CROSSTUBES

CROSSTUBES RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1- Lightly scuff the bonded area using a 320 grit sand paper and clean the area with 41058 wash 'n' wipe

2- Apply magnobond 6398 as per dwg D205-596-107

Magnobond 6398 Batch: \_\_\_\_\_

EXP: \_\_\_\_\_

3-Install supports and clamps per Dwg D205-596-107. Torque clamps to 80-100 in lb. as per dwg

16.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

17.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D205-596-107

Location: \_\_\_\_\_

PPP Rev: \_\_\_\_\_

18.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



MF 09-0331

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

**NOTE:** Date & initial all entries